

Date: Thursday, 14/08/2008 8:22:38 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MAIN PANEL
Job Number	: 41225		
Estimate Number	: 13164		
P.O. Number	:	Part Number	: D37051
This Issue	: 14/08/2008 S.O. No. :	Drawing Number	: D3705 U/R 08.08.14 Rev B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: U/R
Previous Run	: 37293	Material	:
Written By	:	Due Date	: 15/08/2008 Qty: 2 Um: Each
Checked & Approved By	: <u>mf 08-08-14</u>		
Comment	: Est Rev:A 08-01-30 new issue EC verified by:DD		

Additional Product



Job Number:

08.08.22/15
PRELIMINARY ISSUE

Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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Comment: Qty.: 2.1651 sf(s)/Unit Total: 4.3302 sf(s)

6061T6 aluminium sheet .080" thick

(M6061T6S080)

Batch: 108433 IB 8-8-14

FOR ENGINEERING USE ONLY

**PROTOTYPE**

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3705

Dwg Rev: 1bProg Rev: 1b

grain direction along 21.97*

2- Deburr if necessary IB 8-8-14



(2)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



IB 8-8-14



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

08.08.14 (2)



5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1- counter sink as per dwg

2- BEND AS PER DWG D3705



IB 08.08.14 (2)

Date: Thursday, 14/08/2008 8:22:38 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MAIN PANEL

Job Number: 41225

Part Number: D37051

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

**ENGINEERING
APPROVAL**



08-08-20

(2)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WS

FOR ENGINEERING USE ONLY



PD 08-08-15 (2)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



08-08-22 Prototype

Job Completion



U 09.01.24

POSITIVE RECALL

EFFECTIVE 08.08.22

RELEASED

AUTH U

DATE 09.02.17

DART AEROSPACE LTD		Work Order: 41225
Description: MAIN PANEL		Part Number: D3705-1
Inspection Dwg: D3705-1 Rev: u/r		Page 1 of 1

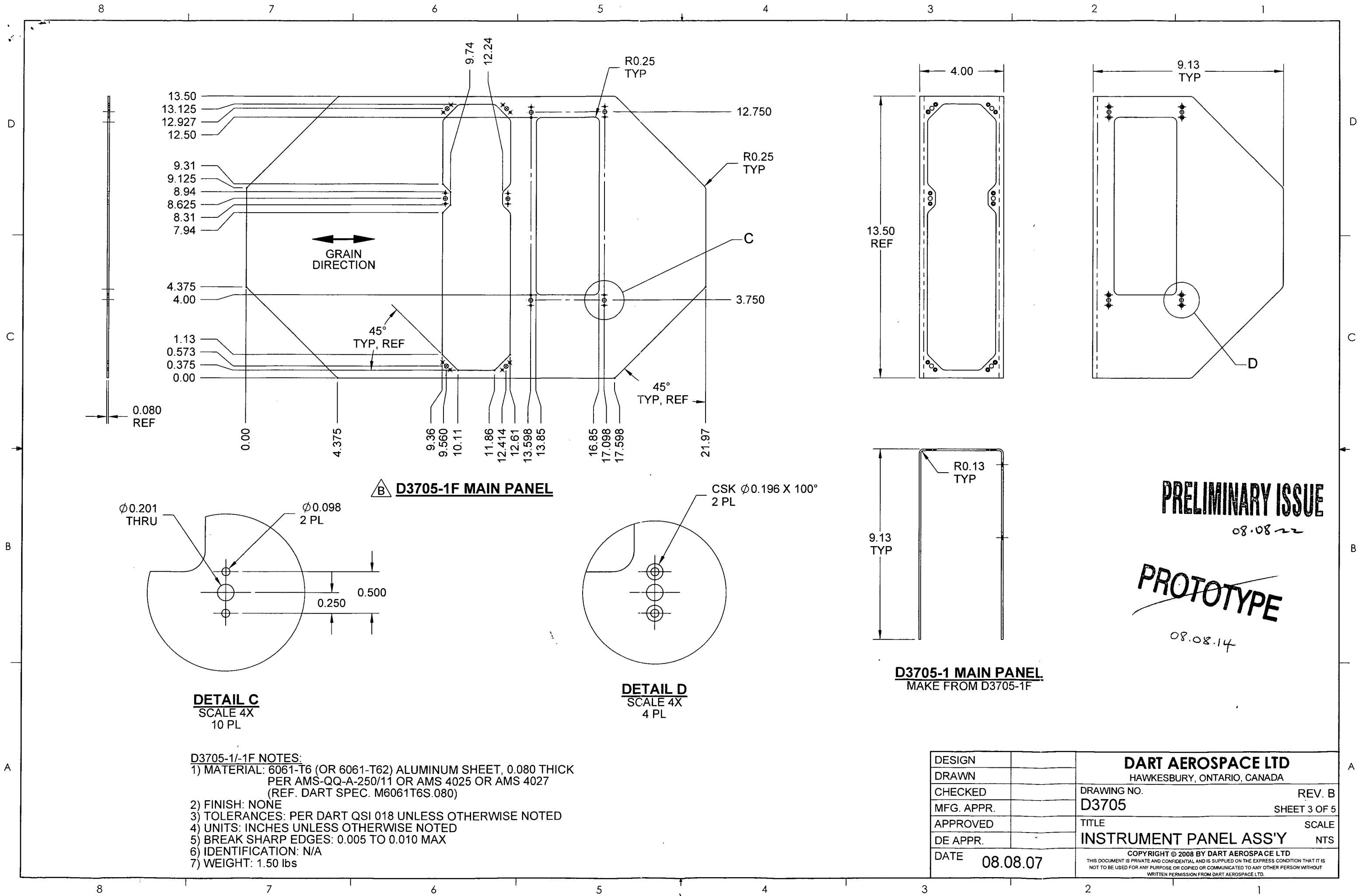
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.098	+ .004 - .001	.102	*			
.201	+ .005 - .001	.203	*			
13.50	+/- .030	13.50	*			
21.97	+/- .030	21.97	*			
4.375	+/- .010	4.378	*			
9.36	+/- .030	9.36	*			
9.560	+/- .010	9.560	*			
12.414	+/- .010	12.414	*			
12.61	+/- .030	12.61	*			
13.598	+/- .010	13.598	*			
13.85	+/- .030	13.85	*			
16.85	+/- .030	16.85	*			
17.098	+/- .010	17.098	*			
.375	+/- .010	.373	*			
.573	+/- .010	.576	*			
1.13	+/- .030	1.133	*			
4.00	+/- .030	4.001	*			
4.375	+/- .010	4.375	*			
7.94	+/- .030	7.94	*			
8.31	+/- .030	8.31	*			
8.625	+/- .010	8.625	*			
8.94	+/- .030	8.94	*			
9.125	+/- .010	9.125	*			

Measured by: RB	Audited by: [Signature]	Prototype Approval: N/A
Date: 8-8-14	Date: 080614	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



DETAIL C
SCALE 4X
10 PL

DETAIL D
SCALE 4X
4 PL

D3705-1 MAIN PANEL
MAKE FROM D3705-1F

D3705-1/-1F NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.50 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3705	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		INSTRUMENT PANEL ASS'Y	NTS
DATE	08.08.07	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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This Issue	: 14/08/2008 S.O. No. :	Drawing Number	: D3705 U/R
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : SMALL /MED FAB	Drawing Revision	: U/R
Previous Run	: 37293	Material	:
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Additional Product

REFERENCE ONLY

Job Number:



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FOR ENGINEERING USE ONLY



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②

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IB 8-8-14

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

10808 14 ②



5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- counter sink as per dwg

2- BEND AS PER DWG D3705



IB 08 08-14 ②

Receiving Report

Date:

8/6/05

Batch No:

17108433

Supplier:

F470556/KRUPP

Dart P/O:

6623

Packing Slip:

Yes

No

Invoice:

Yes

No

Receipt:

Cash

Cr

Release Note Attached:

Yes

No

N/A

Waybill Attached:

Yes

No

N/A

Shipment Complete:

Yes

No

N/A

QC6 Inspection

Yes

N/A

Work Order

Yes

N/A

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

[Signature]

Production/Admin:

Date

08/06/26

Received/Costing

RCP 8231

Initial

CS

Location

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

7:30 AM TO 5:00 PM - MONDAY TO FRIDAY

*** CUSTOMER PICK-UP HOURS ***

*** 9:00 AM TO 4:00 PM ***

* WE STOCK STAINLESS STEEL!!!! *

* PLEASE LET US QUOTE YOUR NEXT REQUIREMENT *

RECEIVED JUL 02 2008

NOTE:

Nouvelle adresse de remise de paiement.
Veuillez s.v.p. indiquer le(s) numéros
de fracture(s) correspondante(s)

NOTE:

Our new remit to address
Please indicate invoice number(s) on all remittances.

Material	Processing	Freight	Other	Taxes	TOTAL DUE
762.24				38.11	800.35

Taxes: GSTSAL	38.11	0.00
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Page: 1 Last

THYSSENKRUPP MATERIALS NA

Certificate of Mill Test Results

BL PEC-000000-000

Pg 1/2

PO/Ref

We certify that this is a true copy of the report furnished by the producer of the metal, or data resulting from tests made in approved labs.

Signed by:

Ann: CHANTAL@DART AERO

PART NO.

DOC : V/0080240236

DATE : 2007-06-25

PROD. REF. : 0000221825/001

NRBST : 08129/01

PAGE : 1 / 2

INSPECTION CERTIFICATE



Aleris Aluminum Duffel BVBA
A Stuckelbaan 87, 2570 Duffel - Belgium

CUSTOMER : ALERIS ALUMINUM US SALES INC.

YOUR ORDER NUMBER : PO9277 (CHARLESTON PO#5166-E)
OUR ORDER NUMBER : 08129/01
DOCUMENT NUMBER : V/0080240236

DESCRIPTION : ALU SHEETS (STENC) AA 6061-T6 AMS-QQA 250/11 ANS 4027M ASTM B209-04,
DIMENSIONS : 144" X 48" X .08"
ARTICLE NO.:

CHEMICAL COMPOSITION (%)

COIL
NUMBER

CAST
NUMBER

	SI	FE	CU	MN	MG	CR	TI	ZN
MIN	0,40		0,15		0,8	0,04		
MAX	0,8	0,7	0,40	0,15	1,2	0,35	0,15	0,25
	0,63	0,4	0,20	0,08	1,0	0,15	0,02	0,02

001 1643381

OTHERS : EACH
TOTAL

MIN
MIN 0,05 MAX
0,15 MAX

MECHANICAL PROPERTIES

(T) = TRANSVERSAL (L) = LONGITUDINAL
1 N/MM2 = 1 MPA = 0,1 HBAR = 0,102 KG/MM2 = 0,145 KSI
/A = REAR END /M = MIDDLE /V = FRONT END /O = RANDOM SAMPLING

TEST-
NUMBER

MIN
MAX

RM
KSI
42

RP02
KSI
35

A
%

001
001
001

/A
/M
/V

40
48
48

41
41
40

16
16
17

Charleston Aluminum LLC
480 Frontage Rd.
Gaston, SC 29053

Aleris Aluminum Duffel BVBA

Indexed 26Sep07 by anand

SEP-21-2007 07:55A FROM CHARLESTON ALUMINUM 803935179

10:15057333033

P.3

PO/Rel

BL PEC-000000-000

We certify that this is a true copy of the report
furnished by the producer of the metal, or data
resulting from tests made in approved labs.

Signed by: _____

Pg 2/2

PART NO.

Attn: CHANTAL @ DART AERO

DOC : V/0080240236

DATE : 2007-06-25

PROD. REF. : 0000221825/001

NREEST : 08129/01

PAGE : 2/ 2



Aleris Aluminum Duffel BVBA
A. Stockman 67, 2570 Duffel - Belgium

DATE SOLUTION HEAT TREATMENT COIL NUMBER
001 STENCILLING : WEEK 24 / YEAR 2007

HEAD OF LABORATORY,
XAVIER SCHELTJENS

Charleston Aluminum LLC
480 Frontage Rd.
Gaston, SC 29053

SEP-21-2007 07:54 FROM: CHARLESTON ALUMINUM 503329175

TO: 1505738003

P.4

Aleris Aluminum Duffel BVBA

Indexed 26Sep07 by anand

